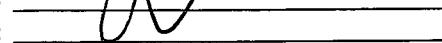


Date: Monday, 1/14/2008 1:25:27 PM
 User: Chantal Lavoie

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: DOUBLER		
Job Number	: 36762		Part Number	: D3140301		
Estimate Number	: 11473		Drawing Number	: D3140 REV F		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 1/14/2008	S.O. No. : N/A	Drawing Revision	: F		
Prsht Rev.	: NC		Material	: N/A		
First Issue	: 1/14/2008	Type : SMALL /MED FAB	Due Date	: 1/16/2008 Qty: 3 Um: Each		
Previous Run	: 34381					
Written By	: 					
Checked & Approved By	: 					
Comment	Est. rev A 02.11.06 New issue Est. Rev B 06.04.18 New dwg rev. ecn781 EST rev.C 06.04.25 Waterjet Est. rev.D added scuffing NCR 061 EC Est Rev:E As per ECN #829 06-11-20 JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6S063	6061-T6 .063 Sheet
Comment: Qty.: 2.9166 sf(s)/Unit Total : 8.7498 sf(s) Material: 6061-T6 (QQ-A-250/11) 0.063" thick (M6061T6S.063) Batch: <u>105325</u> <u>LB 8-1-14</u>		
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per Dwg D <u>3140</u> Dwg Rev: <u>F</u> <u>LB 8-1-14</u> Prog Rev: <u>F</u>		
2-Deburr if necessary <u>LB 8-1-14</u>		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>LB 8-1-14</u>		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK <u>LB 8-1-14</u> <u>08/01/14 (X3)</u>		

Date: Monday, 1/14/2008 1:25:27 PM
User: Chantal Lavoie

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 36762

Part Number: D3140301

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Scuff surfaces with 80grit sandpaper per QSI 006

2-Deburr.

No sharp edges

08/01/15 (3)
INSPECT WORK TO CURRENT STEP

6.0 QC5



Comment: INSPECT WORK TO CURRENT STEP

7.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

m.f 08/01/15

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

AS 08/01/15 x3

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

C 08/01/15 (3)

10.0 QC21

FINAL INSPECTION/W/O RELEASE



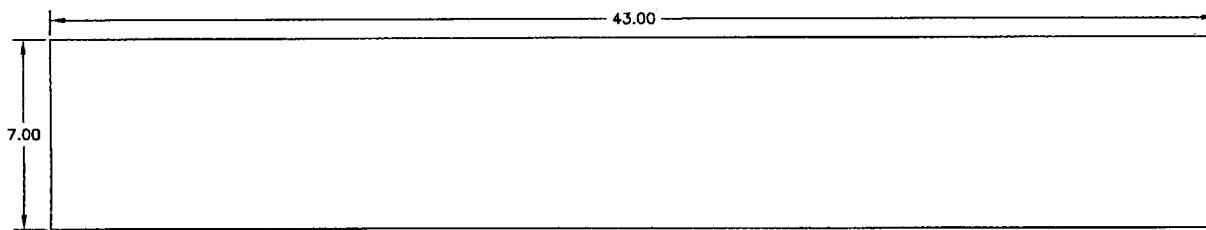
Comment: FINAL INSPECTION/W/O RELEASE

AS 08/01/16

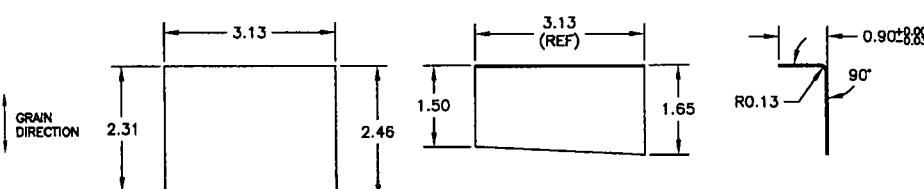
Job Completion



U 08-01-16

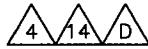


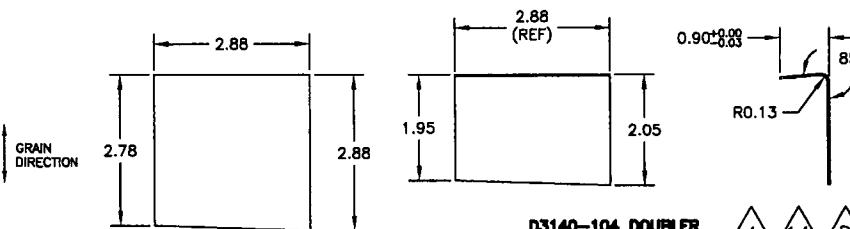
D3140-87 DOUBLER 
(REPLACES PREMIER P/N B30-23000-87)



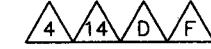
D3140-105F FLAT PATTERN
(USED TO MAKE D3140-105/-106 BRACKETS)

D3140-105 DOUBLER
D3140-106 OPPOSITE

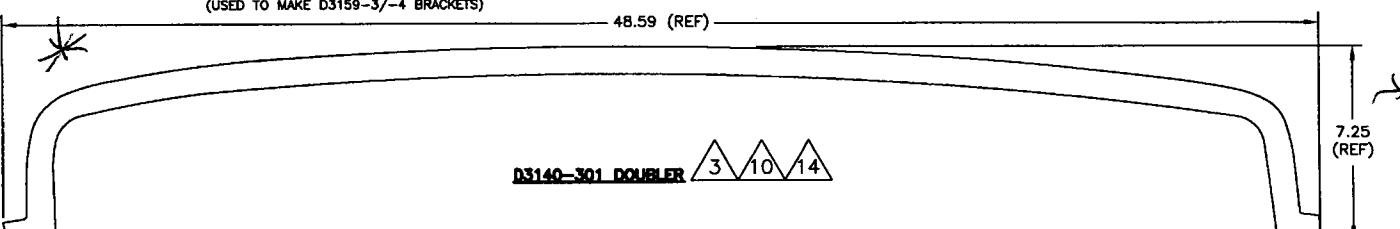




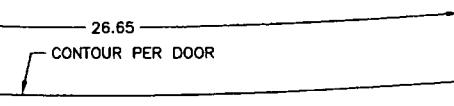
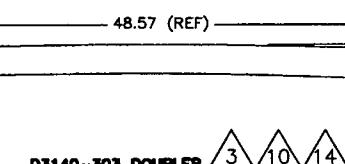
D3140-104 DOUBLER
D3140-103 OPPOSITE



D3140-103F FLAT PATTERN
(USED TO MAKE D3140-103/-104 BRACKETS)



RELEASED
06/11/13 



D3140-85 ANGLE 
FLAT PATTERN: 26.65" x 1.90"
(REPLACES PREMIER P/N B30-23000-85)

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DART AEROSPACE LTD.

DESIGN	DRAWN BY	DART	DART AEROSPACE LTD. HARROWSBURY, ONTARIO, CANADA
4	CB		REV. F
CHECKED 	APPROVED 		DRAWING NO. D3140
DATE 06.10.06			SHEET 6 OF 7 NTS
			TITLE DOOR

010:36762 C808/10/14

DART AEROSPACE LTD	Work Order:	36762
Description: DOUBLER	Part Number:	D 3140-301
Inspection Dwg:D 3140-301 Rev:		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: HB	Audited by: C	Prototype Approval: N
Date: 8-1-14	Date: 08/01/14	Date: 08/01/14

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	